

angle instead of parallel with the center-line, as in Fig. 15. This prevents the plunger from slipping after being clamped. A piece of hardened drill rod *B*, which is kept from turning by a small pin *C*, engaging a flat milled in piece *B*, is used between the plunger *A* and the clamp. A wing-nut *D* is fastened to the

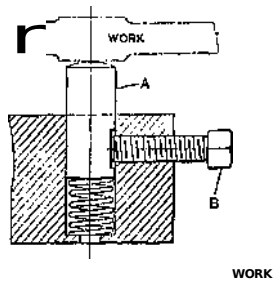


Fig. 15.
Simple
Type of
Adjustable
Stop

Fig. 16.
Improvement on Stop
shown in
Fig. 15

end of the screw as shown, in order to eliminate the use of a wrench.

In Fig. 17 is shown another adjustable stop which presents a further improvement over that shown in Fig. 16. A bronze bushing *B* is driven into the base of the jig and allowed to pro-

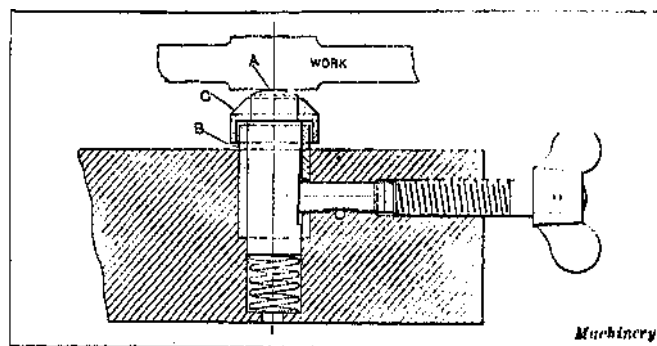


Fig. 17. A Further
Improvement upon
the

**Adjustable
Stops
shown in
Figs. 15
and 16**

ject above the base, as indicated. Plunger *A* is a sliding fit in the bushing. A cap *C* is driven onto the end of the plunger and extends down over the outside of the bushing, as indicated, making the stop dirt-proof. This stop, however, as well as that shown in Fig. 16, is not entirely satisfactory, because it will